# Work Order ID 72782

*Friday, August 12, 2011 2:37:57 PM*



**Item ID:** D206-642-241 **Accept** **Setup Start**

**Revision ID:** **Stop**

**Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 8/19/2011 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run Start**

**Approvals:** **Process Plan:** **Date:** 11-08-12 **Tooling:** **Date:**

**Stop**

**QC:** **Date:** **SPC (Y/N):** **Date:**

SCRAP

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | |
| D2650 | Rev F | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0:00 | | | | | | | |
| DC | | 0:00 | | | | | | | |
| Document Control | **Memo** Photocopy bluefile & type labels per PP D206-642-241 | | CHG005 | | | | | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 110 | | 0.00 | | | | | | | |
| Skidtubes | Skidtubes | | | | | | | | |
| Skidtubes | **Memo** | 0.00 | | | | | | | |

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 > DL/DP 11/09/15

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty ☐ Part Number ☐ Description ☐ Batch
A/R ☐ ☐ Aluminum Rod ☐ M12860 BE 11/09/15

4-Grind weld flush to cap on top surface only. BE 11/09/15

5-Cut Aft end as per dwg 2650 from front of tube and Deburr BE 11/11/08

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. } DL 11/12/05

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. } DL 11/12/05

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**Revision ID:**

**Item Name:** Replacement Skidtube

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**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| | 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. | | | | | | | | |
| | 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 | | | | | | | | |
| | 13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder | | | | | | | | |
| | 14-Remove indexing edge using DT8741 as per Dwg D2650 | | | | | | | | |
| | 15-C'sink GHW rivet holes as per Dwg D2650 | | | | | | | | |
| 120 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DK 11/17/05

PTO

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| W/O: | | 72782 | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** D7046-642-241 **PAR #:** _____ **Fault Category:** Landing Gear Skid tube **NCR:** (Yes) No **DQA:** LF **Date:** 11/12/08

**Resolution:** Scrap **Disposition:** Scrap **QA: N/C Closed:** CK **Date:** 11/12/08

**NCR:** 11-1043

## WORK ORDER NON-CONFORMANCE (NCR)

143437.

| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
|---|---|---|---|---|---|---|---|---|
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| 11/17/05 | 410 | INDEXING RIDGE REMOVED FROM WRONG AREA OF TUBE. R.L. HOA employee located sing in work hole Didn't Pay Attention to Dwg. | S 11/12/05 | Scrap + Destroy no Reuse | 11/17/05 | 11-12-5 | S 11/12/05 | S 11/12/05 |
| | | | 12/08/11 PST042 | | | | 12/08/11 PST042 | |
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**NOTE:** Date & initial all entries

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**Item ID:** D206-642-241 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 8/19/2011 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Run Start** **Stop**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 130 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | **Memo** | 0.00 | | | | | | | |
| Skidtubes | 1-Open crossbolt holes to Ø0.3125"<br>2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.<br>3-Deburr tube and blow out chips from inside the tube | | | | | | | | |
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
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**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | | 0.00 | | | | | | | |
| Skidtubes | Skidtubes | | | | | | | | |
| Skidtubes | **Memo** | 0.00 | | | | | | | |
| Skidtubes | 1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)<br>2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)<br>3-Deburr and blow out all chips from inside the tube | | | | | | | | |
| 170 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 180 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | | | | | | | | | |
| Skidtubes | **Memo** | 0.00 | | | | | | | |
| | 1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required<br><br>2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting<br>Start Date:☐_____☐Time:☐_____☐<br>Finish Date:☐_____☐Time:☐_____<br><br>Pick:<br>Qty ☐Part Number☐Description☐Batch<br>A/R☐☐Sikaflex-291☐_____☐☐<br>Sikaflex expire date:☐_____ | | | | | | | | |
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | **Memo** | 0.00 | | | | | | | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 200 | | 0.00 | | | | | | | |
| Skidtubes | Skidtubes | | | | | | | | |
| Skidtubes | **Memo** | 0.00 | | | | | | | |

Skidtubes

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
Qty☐Part Number☐Description☐Batch
A/R☐☐Aluminum Rod☐_____

3-Grind welds flush as per Dwg D2650.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/R☐SS Rod☐_____

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

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|---|---|---|---|---|---|---|---|---|---|
| 210 | | 0.00 | | | | | | | |
| HandFinish | HandFinishing | | | | | | | | |
| Hand Finishing | **Memo** Install D2680-041 Nut Plate as per Dwg D2650 | 0.00 | | | | | | | |
| 220 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 230 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

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|---|---|---|---|---|---|---|---|---|---|
| 240 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank. | | | | | | | | |
| 250 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| Powdercoat | **Memo** | 0.00 | | | | | | | |
| Powder Coating | START TIME: _____<br>OVEN TEMPERATURE: _____<br>FINISH TIME: _____ | | | | | | | | |
| 260 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

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|---|---|---|---|---|---|---|---|---|---|
| 270 | HandFinishing | 0.00 | | | | | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | 1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.<br>A/R☐☐Sikaflex-291☐_____☐☐<br>Sikaflex expire date:☐_____<br><br>2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.<br><br>3-Install MS27039-4-06 Screw as per DEO 9153.<br><br>4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive<br>A/R☐☐Sikaflex-291☐_____☐☐<br>Sikaflex expire date:☐_____<br><br>5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4<br>A/R Batch:_____☐<br>Batch: _____ | | | | | | | | |
| 300 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Work Order ID 72782

*Friday, August 12, 2011 2:37:57 PM*



**Item ID:** D206-642-241 **Accept** **Setup Start** **Stop**

**Revision ID:**

**Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Start Qty:** 1.00 **Cust Item ID:**

**Required Date:** 8/19/2011 **Req'd Qty:** 1.00 **Customer:**

**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 310 | | 0.00 | | | | | | | |
| Packaging | Packaging | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D206-664-241<br>Location:_____<br>PPP Rev:_____ | | | | | | | | |
| 320 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

MF 11-12-05

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print



*Friday, August 12, 2011 2:38:03 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:** IPP Rev: 04.12.02□Revised procedural steps□KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verified by:EC□IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D2620<br>Skidtube, 206 Skidtube | | Manufactured | No | | | 110 | Each | 18.0000 | 1 | 1 | | | |
| D3286-1<br>Doubler | | Manufactured | No | | | 110 | Each | 32.0000 | 2 | 2 | | | |
| D2647<br>Cap | | Manufactured | No | | | 110 | Each | 44.0000 | 1 | 1 | | | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG | 18 | |
| 68136 | 1 | |
| 71616 | 5 | |
| 71617 | 12 | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG002 | 32 | |
| 52844 | 11 | |
| 64563 | 21 | |

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG002 | 44 | |
| 55352 | 14 | |
| 71171 | 30 | |

11-9-15

BE 11/09/15

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:03 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2654-3 | Manufactured | No | | 180 | Each | 4.0000 | 1 | 1 |

Web

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG | 4 | |
| 64876 | 4 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| CR3212-4-04 | Purchased | No | | 180 | Each | 555.0000 | 52 | 52 |

Cherry Rivet

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST311 | 555 | |
| 116471 | 78 | |
| 117816 | 477 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2649 | Manufactured | No | | 200 | Each | 130.0000 | 18 | 18 |

Cross Bolt Spacer

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG | 118 | |
| 68224 | 2 | |
| 71355 | 2 | |
| 72704 | 114 | |
| LG001 | 12 | |
| 65317 | 1 | |
| 68507 | 11 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3286-3 | Manufactured | No | | 200 | Each | 27.0000 | 2 | 2 |

Spacer

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG002 | 27 | |
| 64564 | 27 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:03 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2680-041 | Manufactured | No | | 210 | Each | 19.0000 | 1 | 1 |

Nut Plate

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST020 | 19 | |
| 55366 | 17 | |
| 70088 | 2 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| CR3212-4-03 | Purchased | No | | 210 | Each | 1,174.000 | 2 | 2 |

Cherry Rivet

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP-B | 2 | |
| 110139 | 2 | |
| ST311 | 1172 | |
| 114859 | 1172 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| CCR264SS3-3 | Purchased | No | | 210 | Each | 471.0000 | 2 | 2 |

Cherry Rivet

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP-B | 2 | |
| 113973 | 2 | |
| ST311 | 469 | |
| 117086 | 43 | |
| 117849 | 426 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:03 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D2646 | Manufactured | No | | 270 | Each | 101.0000 | 1 | 1 | |

Aft Cap

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP004 | 54 | | |
| 68280 | 54 | | |
| FP006 | 5 | | |
| 62678 | 5 | | |
| FP-4 | 38 | | |
| 70945 | 1 | | |
| 71070 | 37 | | |
| fp5 | 4 | | |
| 71038 | 4 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2651-1 | Manufactured | No | | 270 | Each | 289.0000 | 18 | 18 |

Plug

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| fpa | 109 | | |
| 69018 | 109 | | |
| FP-A | 180 | | |
| 57869 | 1 | | |
| 66445 | 10 | | |
| 67760 | 36 | | |
| 70691 | 100 | | |
| 70839 | 2 | | |
| 71037 | 31 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| AN960JD416 | NAS1149D0463J | Purchased | No | 270 | Each | 0.0000 | 1 | 1 |

Washer

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:03 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2651-3 | Manufactured | No | | 270 | Each | 294.0000 | 18 | 18 |

O-Ring

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP-A | 294 | |
| 61962 | 12 | |
| 66956 | 282 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| MS27039-1-08 | Purchased | No | | 270 | Each | 902.0000 | 46 | 46 |

Screw

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST291 | 902 | |
| 115108 | 202 | |
| 117423 | 300 | |
| 118378 | 400 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| ALS4-1032-130 | Purchased | No | | 270 | Each | 2,276.000 | 44 | 44 |

Insert

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST281 | 378 | |
| 117331 | 8 | |
| 118386 | 370 | |
| ST282 | 1898 | |
| 117717 | 54 | |
| 118237 | 1588 | |
| 118312 | 256 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:04 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| MS27039-4-06 | | Purchased | No | | 270 | Each | 37.0000 | 1 | 1 |

Screw

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP-A | 8 | |
| 115460 | 8 | |
| ST292 | 29 | |
| 115460 | 29 | |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| AN960JD10L | NAS1149D0332J | Purchased | No | | 270 | Each | 0.0000 | 46 | 46 |

Washer

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3537-1 | | Manufactured | No | | 270 | Each | 27.0000 | 4 | 4 |

Wearpad

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP | 20 | |
| 71574 | 20 | |
| FP017 | 7 | |
| 69817 | 5 | |
| 70686 | 2 | |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3537-3 | | Manufactured | No | | 270 | Each | 23.0000 | 1 | 1 |

Wearpad

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP | 17 | |
| 70481 | 17 | |
| FP017 | 6 | |
| 35697 | 1 | |
| 72686 | 5 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
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**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:04 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3535-13 Wearshoe | Manufactured | No | | 270 | Each | 1.0000 | 1 | 1 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP018 | 1 | |
| 65930 | 1 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3536-13 Gasket | Manufactured | No | | 270 | Each | 9.0000 | 1 | 1 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP011 | 9 | |
| 70463 | 9 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3535-21 Wearshoe | Manufactured | No | | 270 | Each | 15.0000 | 1 | 1 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP018 | 15 | |
| 65788 | 1 | |
| 70380 | 8 | |
| 70461 | 6 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3536-21 Gasket | Manufactured | No | | 270 | Each | 14.0000 | 1 | 1 |

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP011 | 14 | |
| 61684 | 2 | |
| 70464 | 12 | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
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| | | | | | | | | |

**NOTE:** Date & initial all entries

# Picklist Print

*Friday, August 12, 2011 2:38:04 PM*

**Work Order ID:** 72782

**Parent Item:** D206-642-241

**Parent Item Name:** Replacement Skidtube

**Start Date:** 8/12/2011 **Required Date:** 8/19/2011

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3535-33 | Manufactured | No | | 270 | Each | 18.0000 | 1 | 1 |

Wearshoe

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP019 | 18 | | |
| 70383 | 8 | | |
| 70462 | 10 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3536-33 | Manufactured | No | | 270 | Each | 26.0000 | 1 | 1 |

Gasket

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP012 | 26 | | |
| 70382 | 10 | | |
| 70465 | 16 | | |

**Dart Aerospace Ltd**

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|---|---|---|---|---|---|
| X | | | | **D2650-1** | **SKIDTUBE ASSEMBLY** |
| | X | | | **D2650-3** | **SKIDTUBE ASSEMBLY** |
| | | X | | **D2650-5** | **SKIDTUBE ASSEMBLY** |
| | | | X | **D2650-7** | **SKIDTUBE ASSEMBLY** |
| | | | | | |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| | | | | | |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

F

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72282

11-08-18

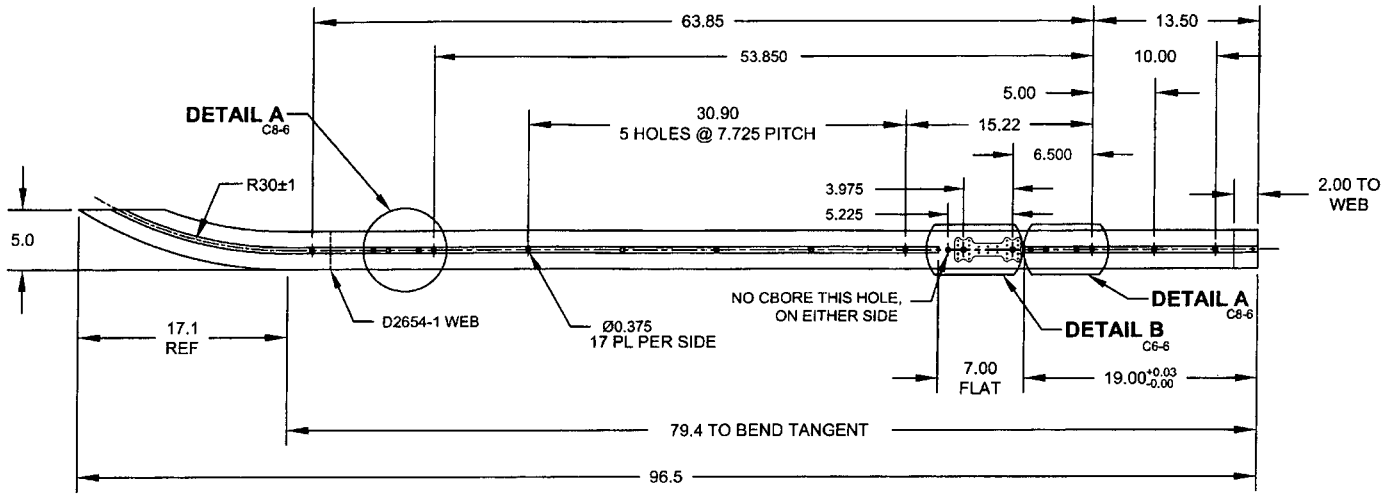
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08.07.23

**NOTES:**

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: N/A
8) WELD PER DART QSI 004
9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

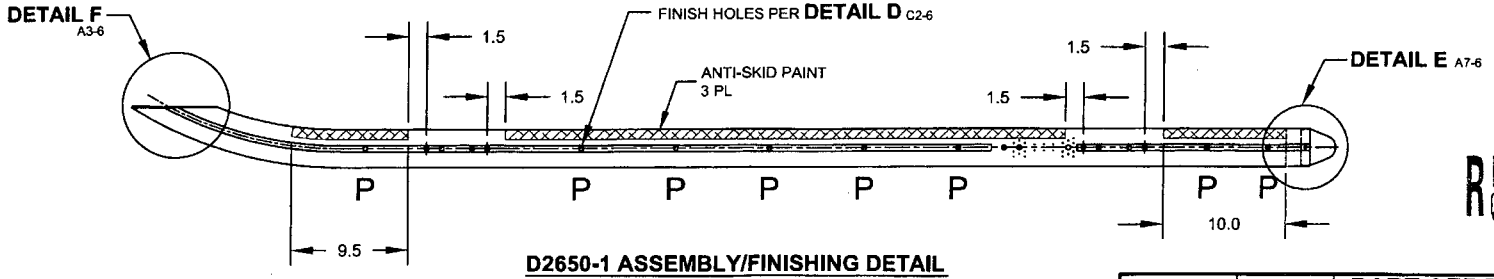
| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | RMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |

| | | | |
|---|---|---|---|
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| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. D2650 | REV. F |
| MFG. APPR. | | | SHEET 1 OF 6 |
| APPROVED | | TITLE 206/407 SKIDTUBE ASSEMBLIES | SCALE NTS |
| DE APPR. | | | |
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**D2650-1 BENDING/DRILLING DETAIL**

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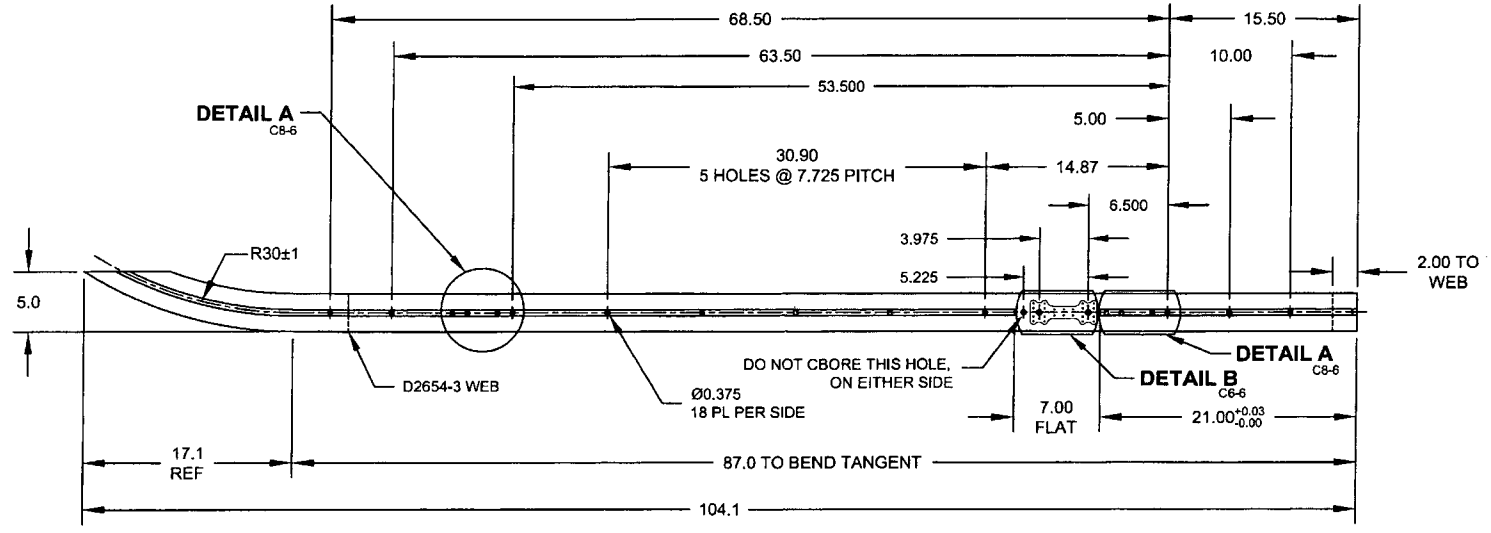



**D2650-1 ASSEMBLY/FINISHING DETAIL**

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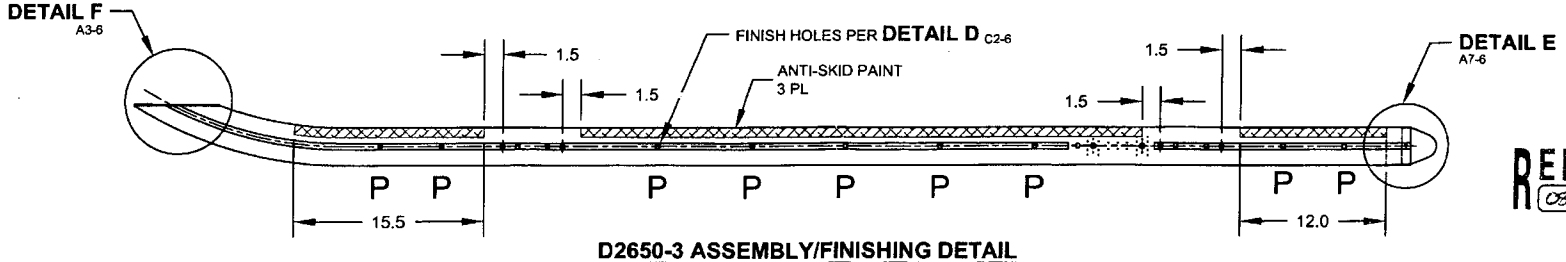
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| MFG. APPR. | | D2650 | SHEET 2 OF 6 |
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**D2650-3 BENDING/DRILLING DETAIL**

72782

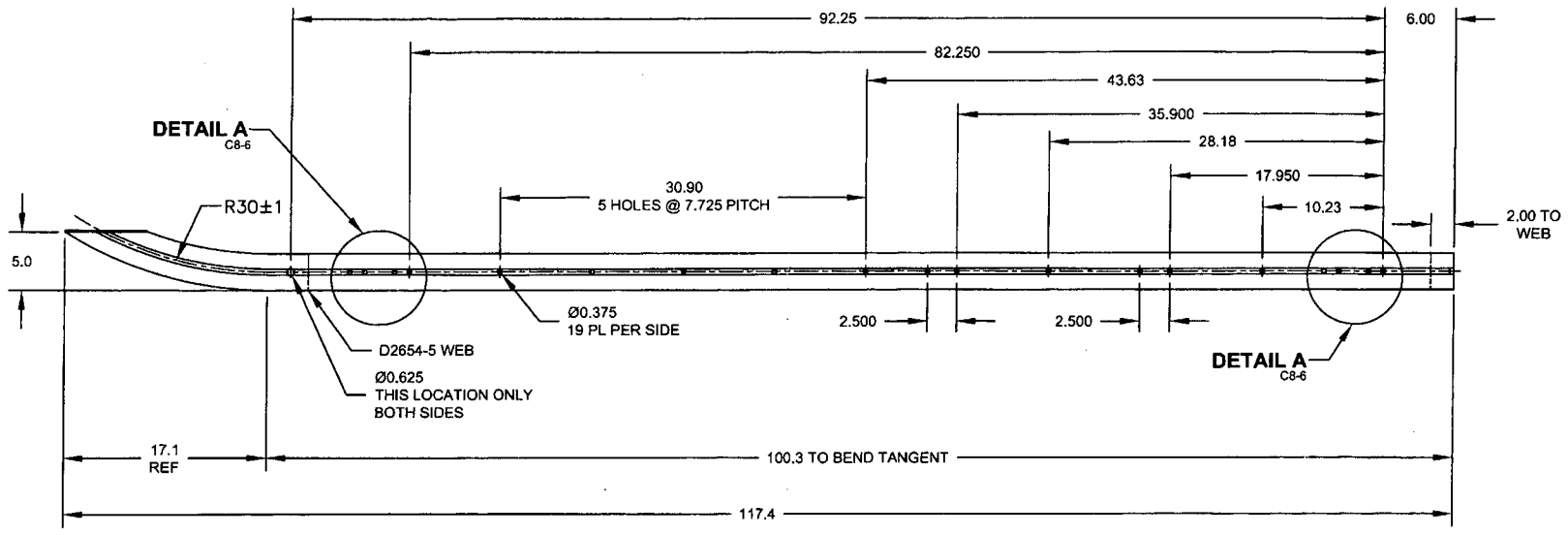



**D2650-3 ASSEMBLY/FINISHING DETAIL**

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05-7-22 KM

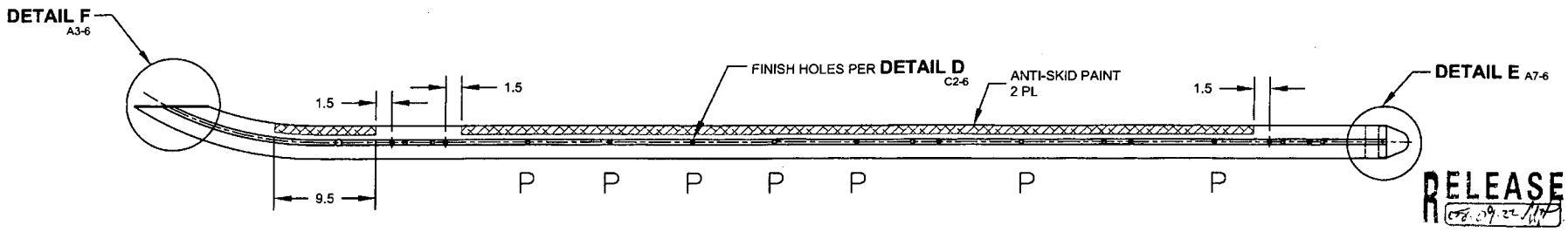
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| DRAWN | AJS | PORT HADLOCK, WA | |
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| MFG. APPR. | | D2650 | SHEET 3 OF 6 |
| APPROVED | | TITLE | SCALE |
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## D2650-5 BENDING/DRILLING DETAIL

77782

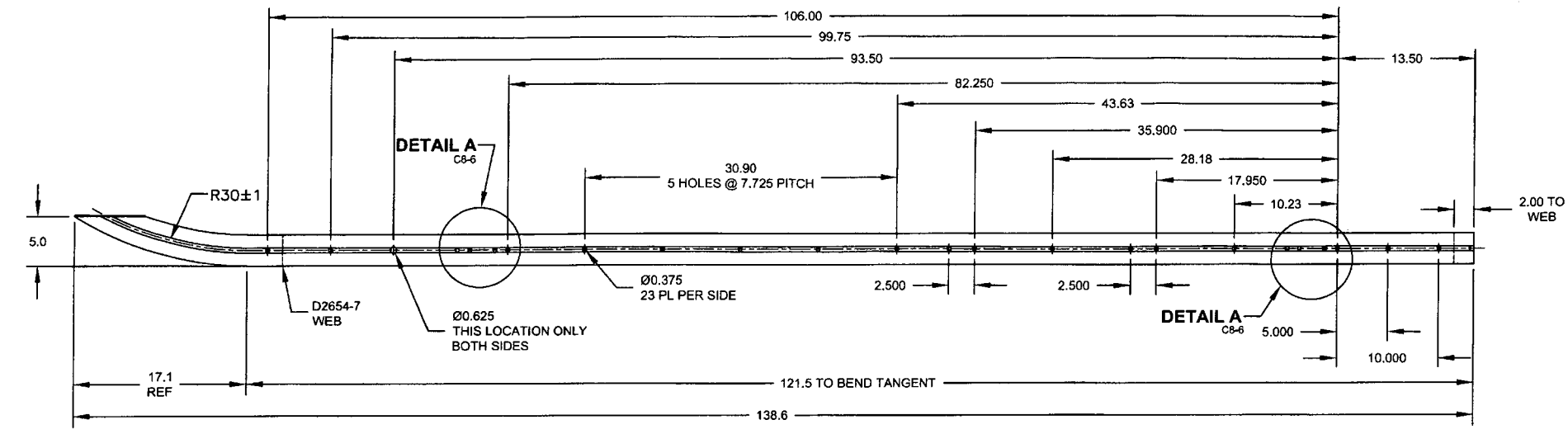



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## D2650-5 ASSEMBLY/FINISHING DETAIL

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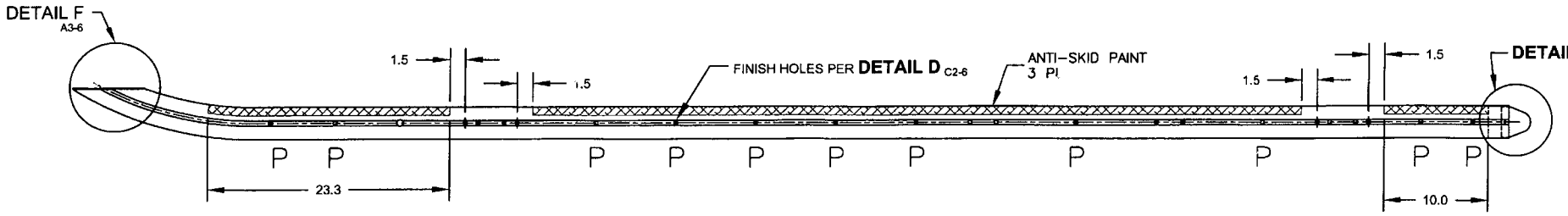
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**D2650-7 BENDING/DRILL DETAIL**

22782

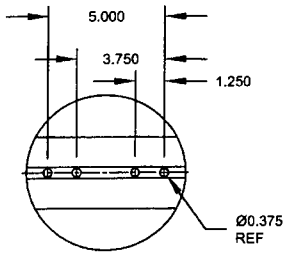
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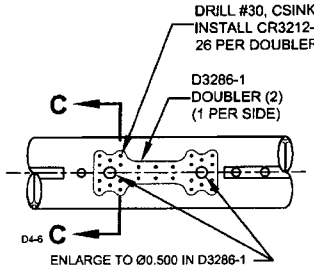

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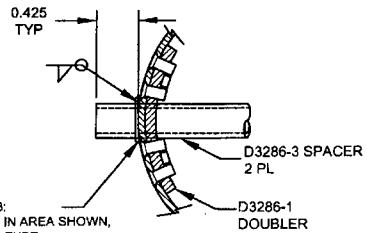



**DETAIL A** C2-2 D7-2 C2-3 D7-3 C2-4 D7-4 C2-5 D6-5
SCALE 2X

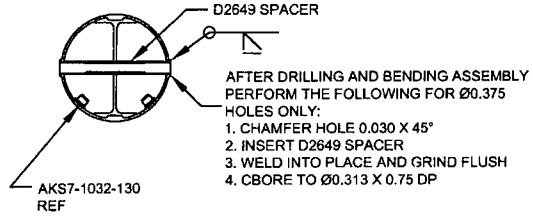



**DETAIL B** C3-2 C3-3
SCALE 2X

**SECTION C-C** C7-6
SCALE NONE

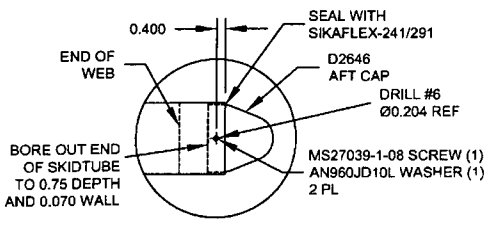



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
F 7. WELD IN PLACE.

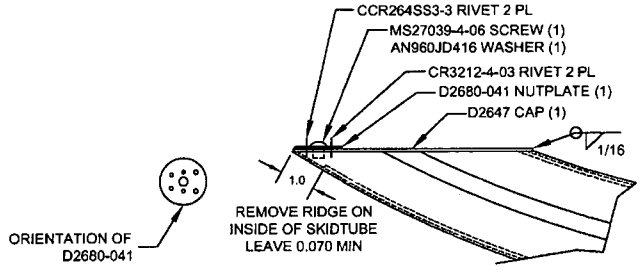



**DETAIL D** B4-2 B4-3 B4-4 B4-5
FOR Ø0.375 HOLES ONLY
SCALE 3X

77782




**DETAIL E** B2-2 B2-3 B1-4 B1-5
SCALE 2X




**DETAIL F** B8-2 B8-3 B8-4 B8-5
SCALE NONE

**DETAIL F NOTES:**
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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